

Work Order ID 86826

86826

Page 1

July-06-12 3:01:07 PM

Item ID: D2207-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Housing Body
 Start Date: 7/06/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/17/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 12-07-9 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2207	Rev C

100 0.00
100 FLOW WATER JET 4 0 Jm 12-7-22
 Waterjet Memo 0.00
 FLOW CNC Waterjet I-Cut as per Dwg D2207 Dwg Rev: C Prog Rev: C 2-
 6061 .063 Debur if necessary

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB 4 0 Jm 12-7-22
 QC Memo 0.00
 Quality Control

120 0.00
120 QC8- Inspect parts - second check 4
 QC Memo 0.00
 Quality Control

SMR
12-7-23
DAS
16
12/19/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86826

July-06-12 3:01:07 PM

86826

Page 2

Item ID: D2207-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Housing Body
 Start Date: 7/06/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/17/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo Bend as per dwg D2207	0.00 0.00				3			PTD SB 12/10/12
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				3	1		
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>W/A</u> Memo *****STOCK IN LARGE FAB*****	0.00 0.00				3			B 12-10-12

W/O: 86826

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2207-1 PAR #: _____ Fault Category: Sm Fab NCR: Yes ☒ No ☐ DQA: Not Date: 12/10/27
 Resolution: _____ Disposition: Scrap QA: N/C Closed: ☒ Date: 12/10/29

NCR: 12-1959

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/10/17	130	1 piece crack at the head R.G. Rod too sharp causes crack / material & design	DAS 16 2-8 Q57042 12/10/17	Scrap & destroy No replace 27(1)	SB 12/10/17	SmB 12/10/17	DAS 16 2-8 Q57042 12/10/17	DAS 16 2-8 12/10/17

\$ 70.09

NOTE: Date & initial all entries

Work Order ID 86826

July-06-12 3:01:07 PM

86826

Page 3

Item ID: D2207-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Housing Body
 Start Date: 7/06/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/17/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/10/22 *[Signature]*

U 12.10.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-06-12 3:01:06 PM

Page 1

Work Order ID: 86826

Parent Item: D2207-1

Parent Item Name: Housing Body

Start Date: 7/06/12

Required Date: 8/17/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A01.03.08New Issue
IPP rev B 07.09.11 ecn 998 EC verified by: JLM

Component Item ID/ Item Name	Replacement item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	505.4868	0.4167	1.7545264 2.0			Jm 12-7-02
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		505.4868320							
				113608		0							
				116308		5.01556842							
				117285		67.544							
				119331		44.2							
				119802		5.94							
				120218		15.86							
				120866		64.8126316							
				121805		302.114632							
				121578						121578			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

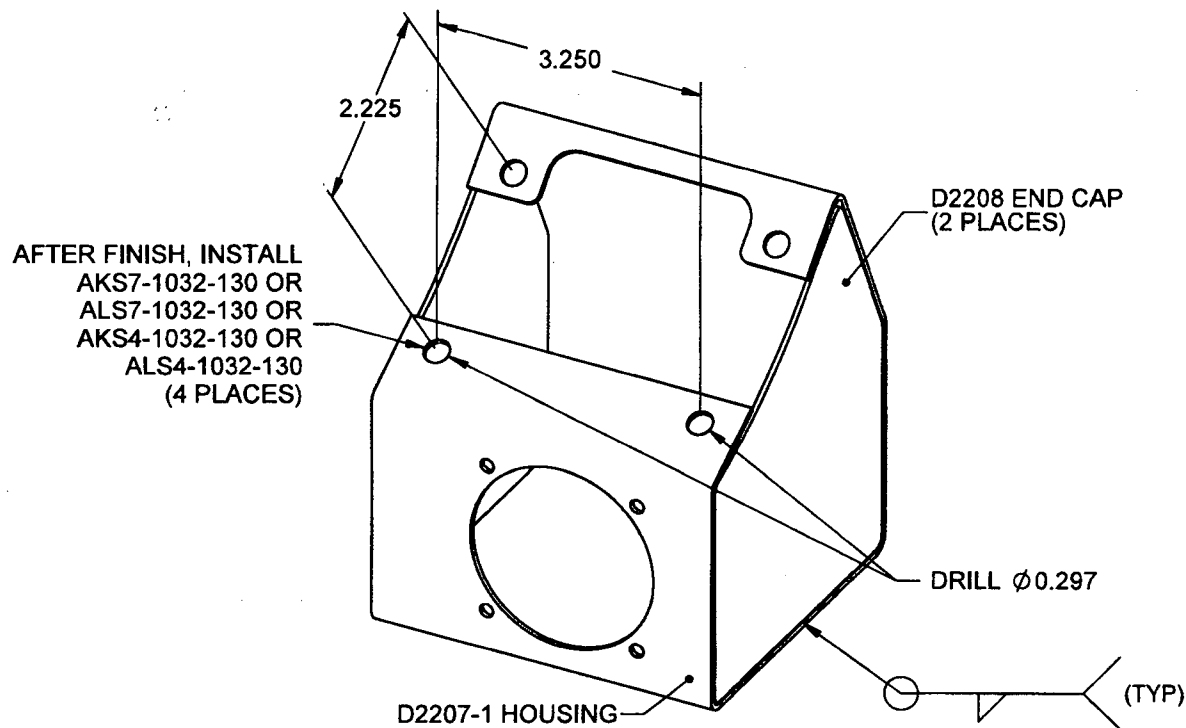
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *86826*

12-07-9

RELEASED
07-08-29

D2207-041 HOUSING ASSEMBLY

C	- UPDATE FLAT PATTERN - TOOLING REWORK REQUIRED	MB	07.06.28
B	REDRAWN	RF	01.02.23
A	NEW ISSUE	RF	94.09.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PH</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	D2207	SHEET 1 OF 2
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	HOUSING	1:2
DATE	07.06.28	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

NOTES:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

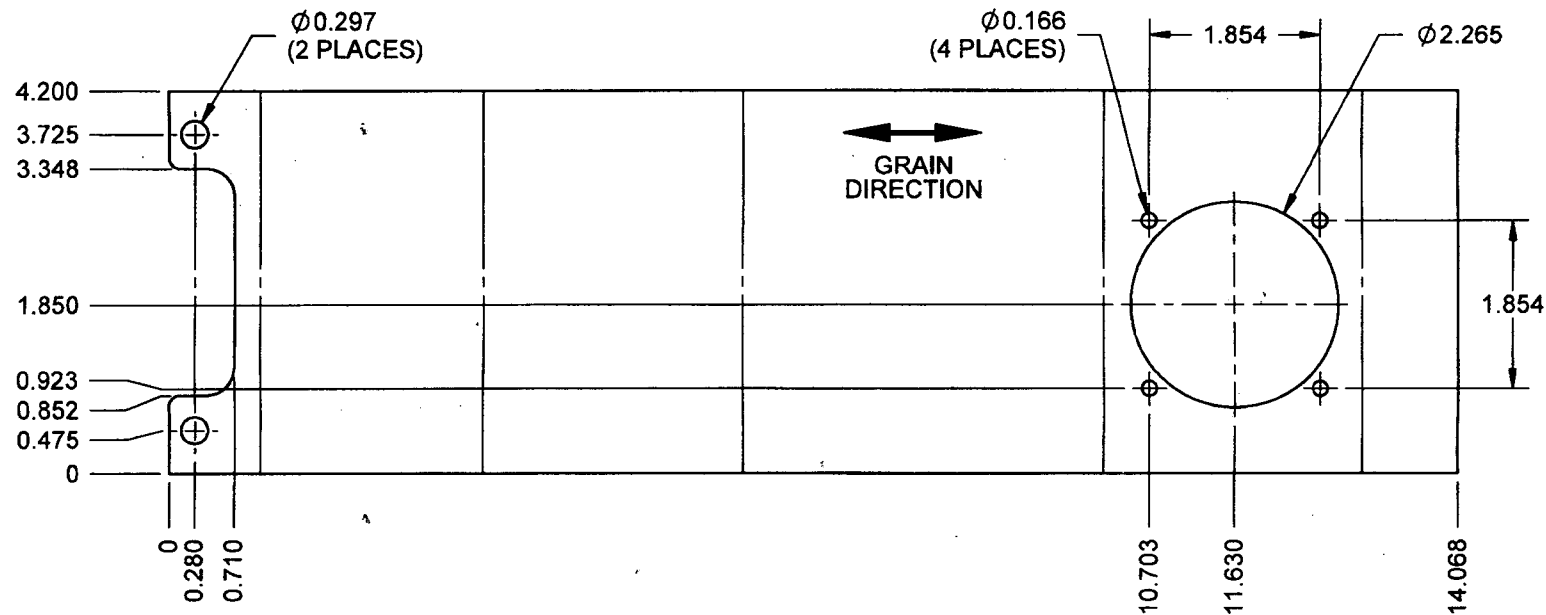
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

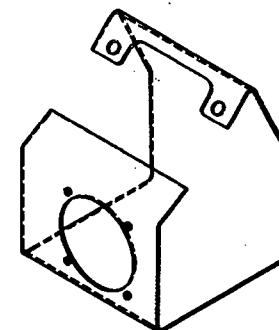
NOTE: Date & initial all entries



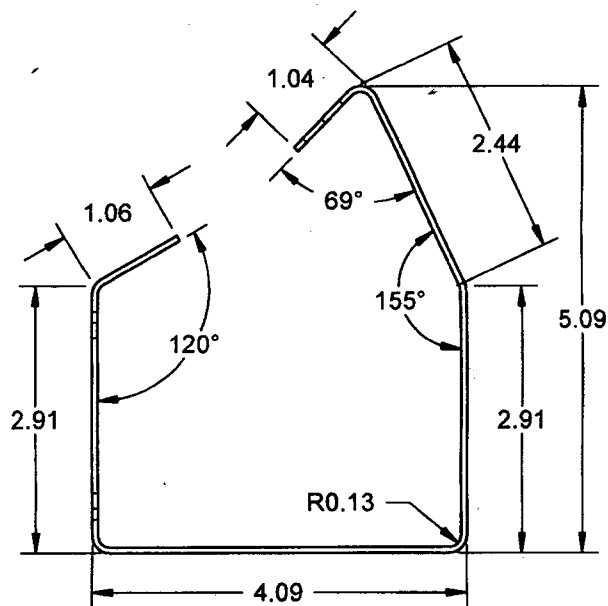
D2207-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



ISOMETRIC VIEW
(SCALE 1 : 4)



D2207-1 BENDING DETAIL

RELEASED

07.08.29

DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	D2207	SHEET 2 OF 2
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	HOUSING	1:2
DATE	07.06.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries